



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4073-1

Job Sheet 172583



Part No: D4073-1

Job Qty: 20 ea

Part Name: AW139 Door Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Machining-2		2018-18/03/15
100	Bandsaw	20 pcs	3/8/18	3/8/18	0.00	0.27	Bandsaw1		11
105	CNC Vertical Machining	20 pcs	3/8/18	3/8/18	0.18	9.39	HAAS1-4		
120	QC	20 pcs	3/8/18	3/8/18	0.00	0.00	QC8 Machining-2		2018-18/03/20
150	HandFinish	20 pcs	3/8/18	3/8/18	0.00	0.42	HandFinish1		SA 18-3-21
160	Powdercoat	20 pcs	3/9/18	3/9/18	0.00	0.33	Powdercoat1		BL 18-3-22
170	QC	20 pcs	3/9/18	3/9/18	0.00	0.00	QC3		11
180	Packaging	20 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-2	57073	MAR 23 2018
190	QC21-SA	20 Ea	3/9/18	3/9/18	0.00	0.00	QC21		MAR 23 2018

Part Op 100 - cut blank 4.563" long

Descriptions: 105 - Mill as per Dwg an Folio FA939

M 138760 START: 1:10 O.V.T. 320° FINISH: 1:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	7.6000 ft (.38 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X01.250	8	25	0

tot = 7.9 ft

5048655

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Hinge	0.130Inches $\pm$ 0.030	0.160 0.100	.130	Radius
2	Door Hinge	0.203Inches $\pm$ 0.005 - 0.001	0.208 0.202	.203	Diameter
3	Door Hinge	2.000Inches $\pm$ 0.030	2.030 1.970	1.998	
4	Door Hinge	0.810Inches $\pm$ 0.030	0.840 0.780	.810	
5	Door Hinge	0.350Inches $\pm$ 0.010	0.360 0.340	.350	
6	Door Hinge	1.100Inches $\pm$ 0.010	1.110 1.090	1.103	
7	Door Hinge	0.500Inches $\pm$ 0.010	0.510 0.490	.500	Diameter
8	Door Hinge	0.125Inches $\pm$ 0.010	0.135 0.115	.126	
9	Door Hinge	0.340Inches $\pm$ 0.010	0.350 0.330	.340	
10	Door Hinge	1.320Inches $\pm$ 0.010	1.330 1.310	1.320	
11	Door Hinge	4.440Inches $\pm$ 0.030	4.470 4.410	4.437	
12	Door Hinge	4.130Inches $\pm$ 0.030	4.160 4.100	4.125	
13	Door Hinge	0.310Inches $\pm$ 0.030	0.340 0.280	.310	Radius
14	Door Hinge	0.313Inches $\pm$ 0.010	0.323 0.303	.314	
15	Door Hinge	0.630Inches $\pm$ 0.030	0.660 0.600	.625	
16	Door Hinge	1.000Inches $\pm$ 0.030	1.030 0.970	1.002	
17	Door Hinge	0.380Inches $\pm$ 0.030	0.410 0.350	.380	
18	Door Hinge	0.190Inches $\pm$ 0.010	0.200 0.180	.191	
19	Door Hinge	1.800Inches $\pm$ 0.030	1.830 1.770	1.802	
20	Door Hinge	0.250Inches $\pm$ 0.030	0.280 0.220	.247	
21	Door Hinge	0.130Inches $\pm$ 0.030	0.160 0.100	.130	Radius

Plex 2/20/18 2:46 PM Dart.Gagnon.Michelle



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Container No: S051958



Part: D4073-1

Job No: 172583

Serial No/Batch: S051958

Revision:

Inspector:

Date: 03/15/18

